

Work Order ID 129064

Wednesday, January 28, 2015 9:05:50 AM

129064

Page 1

Item ID: D3883-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Outboard LH

Start Date: 1/28/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/28/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 150128

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3883

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 129064Double check by: ASD 15/04/19

1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets

MILL AS PER DWG AND FOLIO FA815

FOLIO REV: AADWG REV: C

150416 6 1 JFC 2015-04-19

105

0.00

105

Mill Conv

Memo

0.00

Conventional Milling Machine

MILL KEYWAY AS PER DWG

[Signature] 6 1 Jfc 2015-04-19

DQA:

Date:

15/06/05



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/06/01

Work Order update only



Work Order: <u>129064</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No: <u>D 3883-1</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-04-17	100	1	Dim of top of Gusset 100" under		Scrap + Destroy			
Doc/Data						Replm			
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

Dim of top of Gusset
100" under

AC offset in folio
was -3.891 instead of
-4.000

Q32042
15/04/21

Scrap + Destroy
Replm
129885

Adjust folio to
have correct
adjustment
D.A. 15/04/28

15-04-06

15/04/21

DAS
9
9-89

15-04-29

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☒ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, January 28, 2015 9:05:53 AM

Page 1

Work Order ID: 129064

129064

Parent Item: D3883-1

D3883-1

Parent Item Name: Saddle, Outboard LH

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015		Manufactured	No			100	Each	8.0000	1	6			

D6101-015

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

5

127518

5

MAT045

3

124323

3

129885

76

JFL 2015-04-14

DART AEROSPACE LTD		Work Order:	129064
Description: Saddle, Outboard, LH		Part Number:	D3883-1
Inspection Dwg: D3883	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.641	0.642	0.642	0.642		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.613	0.612	0.614	0.614		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.0014	2.005	2.004		
J	0.140	0.165		0.145	0.150	0.150	0.151		
K	0.240	0.260		0.244	0.249	0.249	0.250		
L	0.115	0.135		0.125	0.124	0.125	0.126		
M	0.140	0.165		0.148	0.148	0.147	0.148		
N	0.720	0.780		0.704	0.778	0.778	0.778		
O	0.240	0.260		0.160	0.251	0.251	0.251		
P	0.110	0.140		0.139	0.139	0.139	0.139		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.855	2.855	2.855	2.855		
S	0.316	0.321		0.317	0.317	0.317	0.317		
T	0.990	1.010		1.005	1.008	1.001	1.001		
U	1.745	1.755		1.752	1.752	1.752	1.752		
V	5.990	6.010		6.000	6.002	6.002	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.497	0.506	0.499	0.498		
Y	1.220	1.280		1.254	1.252	1.252	1.252		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.314	0.314	0.314	0.314		
AB	0.020	0.040		0.030	0.030	0.030	0.030		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.219	0.219	0.219	0.219		
AE	1.265	1.285		1.2678	1.2668	1.270	1.269		
AF									
Accept/Reject				reject	✓	✓	✓		

Measured by:	JUTZ
Date:	2015-04-18

Audited by:	B.A.	DAS
Date:	15/04/28	08
		9-89

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	

DART AEROSPACE LTD		Work Order: 129064
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. C	Page 1 of 1

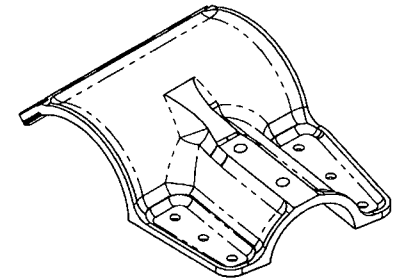
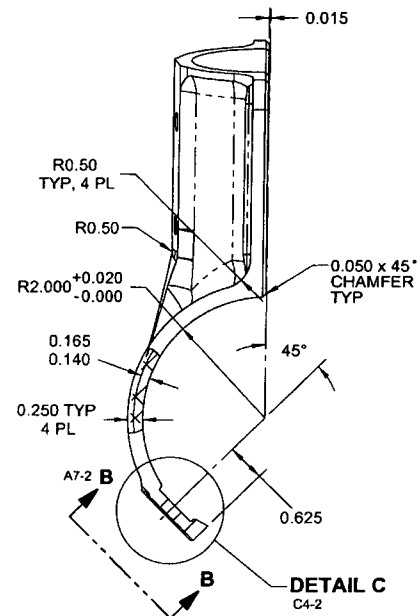
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	35	36	37	4		
A	2.870	2.880		2.875	2.875	2.875			
B	1.433	1.443		1.438	1.438	1.438			
C	0.638	0.658		0.643	0.642	0.642			
D	3.895	3.905		3.900	3.900	3.900			
E	0.257	0.262		0.258	0.258	0.258			
F	0.605	0.625		0.615	0.616	0.613			
G	1.120	1.130		1.125	1.125	1.125			
H	2.245	2.255		2.250	2.250	2.250			
I	2.000	2.020		2.0035	2.002	2.0028			
J	0.140	0.165		0.250	0.2505	0.150			
K	0.240	0.260		0.153	0.153	0.252			
L	0.115	0.135		0.124	0.125	0.125			
M	0.140	0.165		0.149	0.148	0.148			
N	0.720	0.780		0.778	0.778	0.778			
O	0.240	0.260		0.257	0.257	0.253			
P	0.110	0.140		0.139	0.139	0.139			
Q	0.178	0.198		0.188	0.188	0.188			
R	2.825	2.885		2.855	2.855	2.855			
S	0.316	0.321		0.317	0.317	0.317			
T	0.990	1.010		1.001	1.002	1.007			
U	1.745	1.755		1.752	1.752	1.752			
V	5.990	6.010		6.007	6.000	6.000			
W	1.245	1.255		1.250	1.250	1.250			
X	0.490	0.510		0.499	0.499	0.4985			
Y	1.220	1.280		1.252	1.252	1.252			
Z	2.495	2.505		2.500	2.500	2.500			
AA	0.313	0.318		0.314	0.314	0.314			
AB	0.020	0.040		0.030	0.030	0.030			
AC	0.760	0.765		0.760	0.760	0.760			
AD	0.215	0.220		0.219	0.219	0.219			
AE	1.265	1.285		1.2687	1.2675	1.2678			
AF									
Accept/Reject				✓	✓	✓			

Measured by: Jfc
Date: 2015-04-019

Audited by: H.e	DAS
Date: 15/04/28	08
	9-89

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	



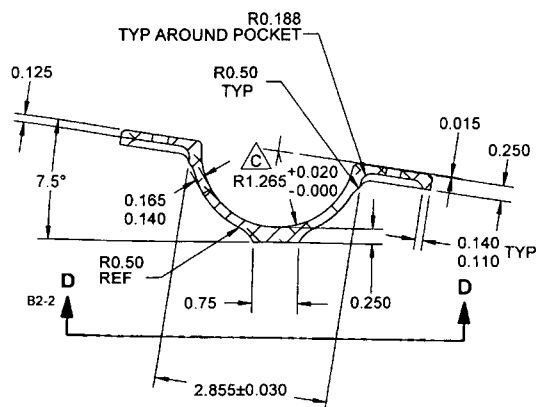
129064.MCS
1501-28

RELEASED
2009-11-19
Wyo

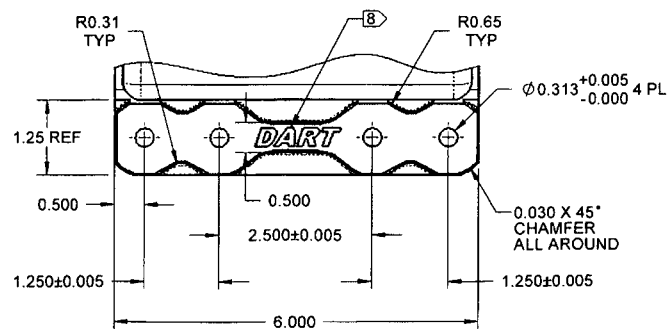
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

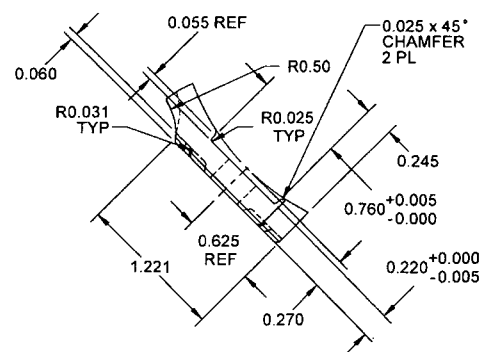
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3883	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD SADDLE	NTS
DATE	09.11.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



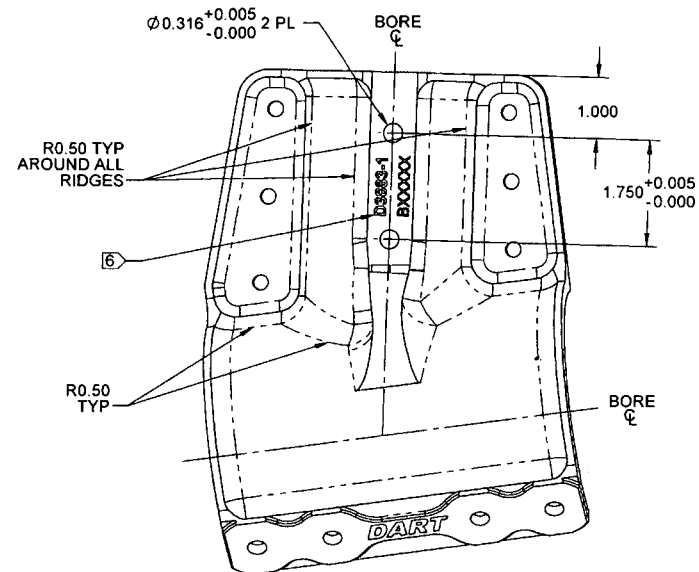
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X



VIEW D-D C7-2

RELEASED
2009-11-19
MP

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3883	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD SADDLE	NTS
DATE	09.11.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Part Number: D3883-1	Rev: C	- Page 1 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 129064

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
A Distance XY	2.875	0.005 -0.005	2.876	2.875	2.876	2.876	2.878
B Distance XY	1.438	0.005 -0.005	1.438	1.438	1.438	1.439	1.439
C Distance XY	0.650	0.010 -0.010	0.646	0.648	0.647	0.647	0.646
D Distance XY	3.900	0.010 -0.010	3.899	3.898	3.898	3.898	3.900
E Diameter	0.2570	0.0050 -0.0010	0.2573	0.2575	0.2576	0.2575	0.2575
F Distance XY	0.615	0.010 -0.010	0.617	0.618	0.618	0.618	0.619
G Distance XY	1.125	0.005 -0.005	1.125	1.126	1.125	1.126	1.125
H Distance XY	2.250	0.005 -0.005	2.252	2.251	2.251	2.251	2.250
I Formula calculation	2.000	0.020 0.000	2.001	2.005	2.004	2.003	2.002
J Formula calculation	0.140	0.025 0.000	0.150	0.150	0.151	0.153	0.153
K Formula calculation	0.250	0.010 -0.010	0.249	0.249	0.250	0.250	0.250
L Distance YZ	0.125	0.010 -0.010	0.123	0.125	0.125	0.123	0.124
M Formula calculation	0.140	0.025 0.000	0.148	0.147	0.148	0.149	0.148
N Formula calculation	0.750	0.030 -0.030	0.778	0.778	0.778	0.778	0.778
O Formula calculation	0.250	0.010 -0.010	0.254	0.251	0.251	0.252	0.252
P Formula calculation	0.125	0.015 -0.015	0.139	0.139	0.139	0.139	0.139
Q Radius	0.188	0.010 -0.010	0.198	0.198	0.196	0.198	0.198
R Distance XY	2.855	0.030 -0.030	2.856	2.856	2.856	2.855	2.855
S Diameter	0.3160	0.0050 -0.0010	0.3163	0.3157	0.3156	0.3153	0.3155

Measured by:
Mathieu Lamarche

Date:
2015-5-10

Audited by:

Date:



Part Number: D3883-1	Rev: C	- Page 2 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 129064

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
T Distance XY	1.000	0.010 -0.010	1.006	0.999	0.999	1.000	1.000
U Distance XY	1.750	0.005 0.000	1.750	1.750	1.750	1.750	1.750
V Distance XY	6.000	0.010 -0.010	6.000	6.000	6.000	6.000	6.000
W Distance XY	1.250	0.005 -0.005	1.251	1.251	1.251	1.250	1.251
X Distance XY	0.500	0.010 -0.010	0.506	0.501	0.500	0.502	0.499
Y Formula calculation	1.250	0.030 -0.030	1.252	1.252	1.252	1.252	1.252
Z Distance XY	2.500	0.005 -0.005	2.500	2.499	2.499	2.499	2.499
AA Diameter	0.3130	0.0050 -0.0010	0.3135	0.3132	0.3127	0.3131	0.3136
AB Formula calculation	0.030	0.010 -0.010	0.030	0.030	0.030	0.030	0.030
AC Formula calculation	0.760	0.005 0.000	0.760	0.760	0.760	0.760	0.760
AD Formula calculation	0.220	0.000 -0.005	0.219	0.219	0.219	0.219	0.219
AE Formula calculation	1.265	0.020 0.000	1.267	1.270	1.269	1.269	1.268

Measured by:
Mathieu Lamarche

Date:
2015-5-10

Audited by:

Date:



Part Number: D3883-1	Rev: C	- Page 1 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 129064

Element name	Nominal	UpperTol	LowerTol	Actual	Deviation	TolBar
A	2.875	0.005	-0.005	2.876	0.001	*****
B	1.438	0.005	-0.005	1.438	0.000	*****
C	0.650	0.010	-0.010	0.647	-0.003	-----*
D	3.900	0.010	-0.010	3.900	0.000	-----
E	0.2570	0.0050	-0.0010	0.2577	0.0007	-----**
F	0.615	0.010	-0.010	0.618	0.003	*****
G	1.125	0.005	-0.005	1.125	0.000	*****
H	2.250	0.005	-0.005	2.251	0.001	*****
I	2.000	0.020	0.000	2.003	0.003	-----****
J	0.140	0.025	0.000	0.150	0.010	-----***
K	0.250	0.010	-0.010	0.252	0.002	*****
L	0.125	0.010	-0.010	0.123	-0.002	-----***
M	0.140	0.025	0.000	0.148	0.008	-----*
N	0.750	0.030	-0.030	0.778	0.028	*****
O	0.250	0.010	-0.010	0.253	0.003	*****
P	0.125	0.015	-0.015	0.139	0.014	*****
Q	0.188	0.010	-0.010	0.198	0.011	-----+--->>
R	2.855	0.030	-0.030	2.856	0.001	*****
S	0.3160	0.0050	-0.0010	0.3153	-0.0007	-----*****
T	1.000	0.010	-0.010	1.000	0.000	*****
U	1.750	0.005	0.000	1.750	0.000	<-----+
V	6.000	0.010	-0.010	6.000	0.000	*****
W	1.250	0.005	-0.005	1.251	0.001	*****
X	0.500	0.010	-0.010	0.500	0.000	*****
Y	1.250	0.030	-0.030	1.252	0.002	*****
Z	2.500	0.005	-0.005	2.499	-0.001	-----*
AA	0.3130	0.0050	-0.0010	0.3124	-0.0006	-----*****
AB	0.030	0.010	-0.010	0.030	0.000	*****
AC	0.760	0.005	0.000	0.760	0.000	-----*****

Measured by: Mathieu Lamarche	Audited by:	Preliminary Approval:
Date: 2015-5-10	Date:	Date:

Figure 1. The effect of the concentration of the *Agrobacterium* suspension on the transformation efficiency of *Agrobacterium* strains. The concentration of the *Agrobacterium* suspension was 10⁶ cells/ml (a), 10⁷ cells/ml (b), 10⁸ cells/ml (c), and 10⁹ cells/ml (d). The concentration of the *Agrobacterium* suspension was 10⁶ cells/ml (a), 10⁷ cells/ml (b), 10⁸ cells/ml (c), and 10⁹ cells/ml (d). The concentration of the *Agrobacterium* suspension was 10⁶ cells/ml (a), 10⁷ cells/ml (b), 10⁸ cells/ml (c), and 10⁹ cells/ml (d). The concentration of the *Agrobacterium* suspension was 10⁶ cells/ml (a), 10⁷ cells/ml (b), 10⁸ cells/ml (c), and 10⁹ cells/ml (d).

1. *Journal of the American Medical Association*, 1990; 263: 1025-1026.

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Part Number: D3883-1	Rev: C	- Page 2 -
Description: OUTBOARD SADDLE	Inspection Dwg: D3883	Work Order: 129064

Element name	Nominal	UpperTol	LowerTol	Actual	Deviation	TolBar
AD	0.220	0.000	-0.005	0.219	-0.001	*****____
AE	1.265	0.020	0.000	1.268	0.003	____*****

Measured by: Mathieu Lamarche	Audited by:	Preliminary Approval:
Date: 2015-5-10	Date:	Date:

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

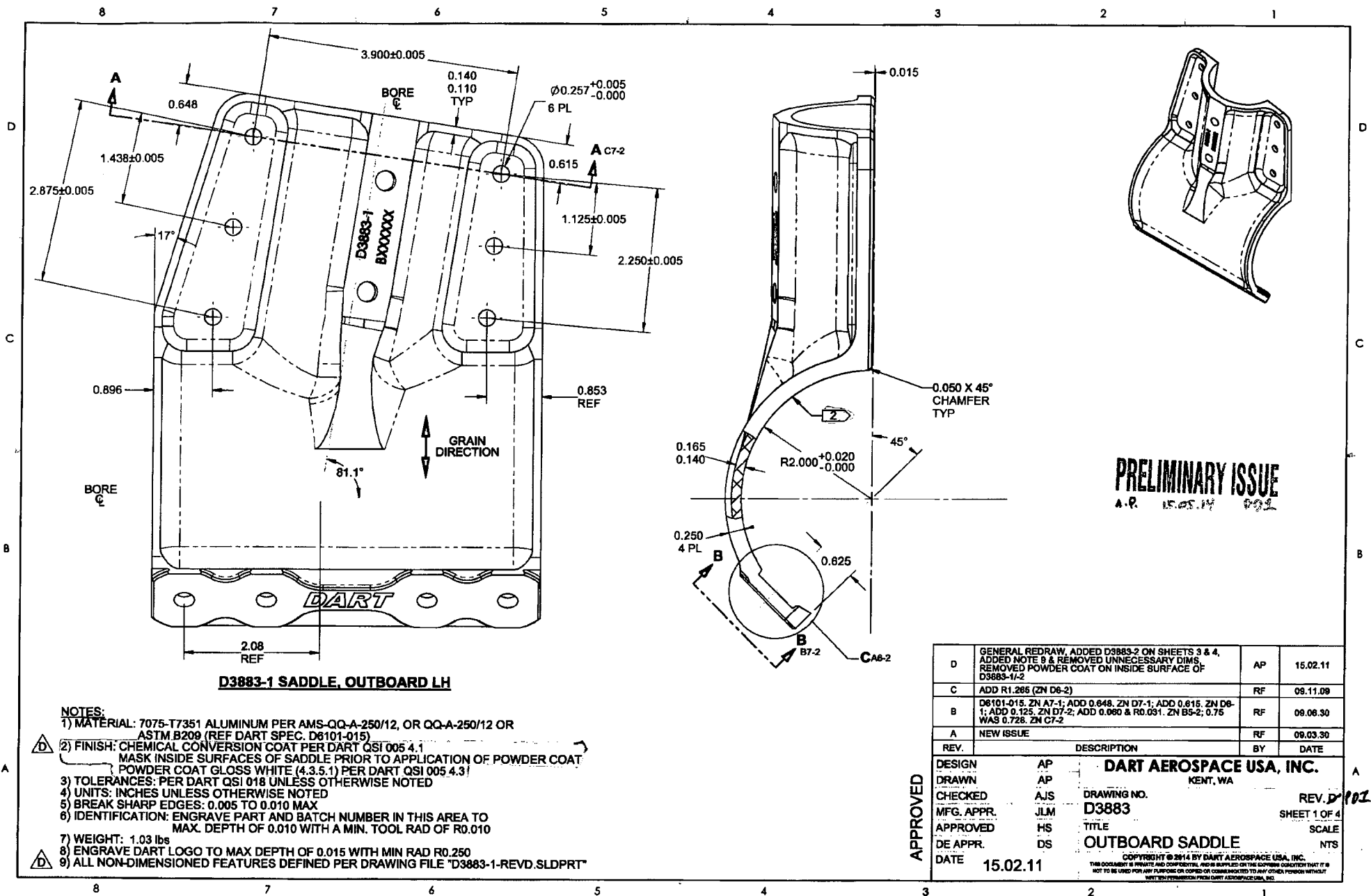
QA Closed: _____ Date: _____

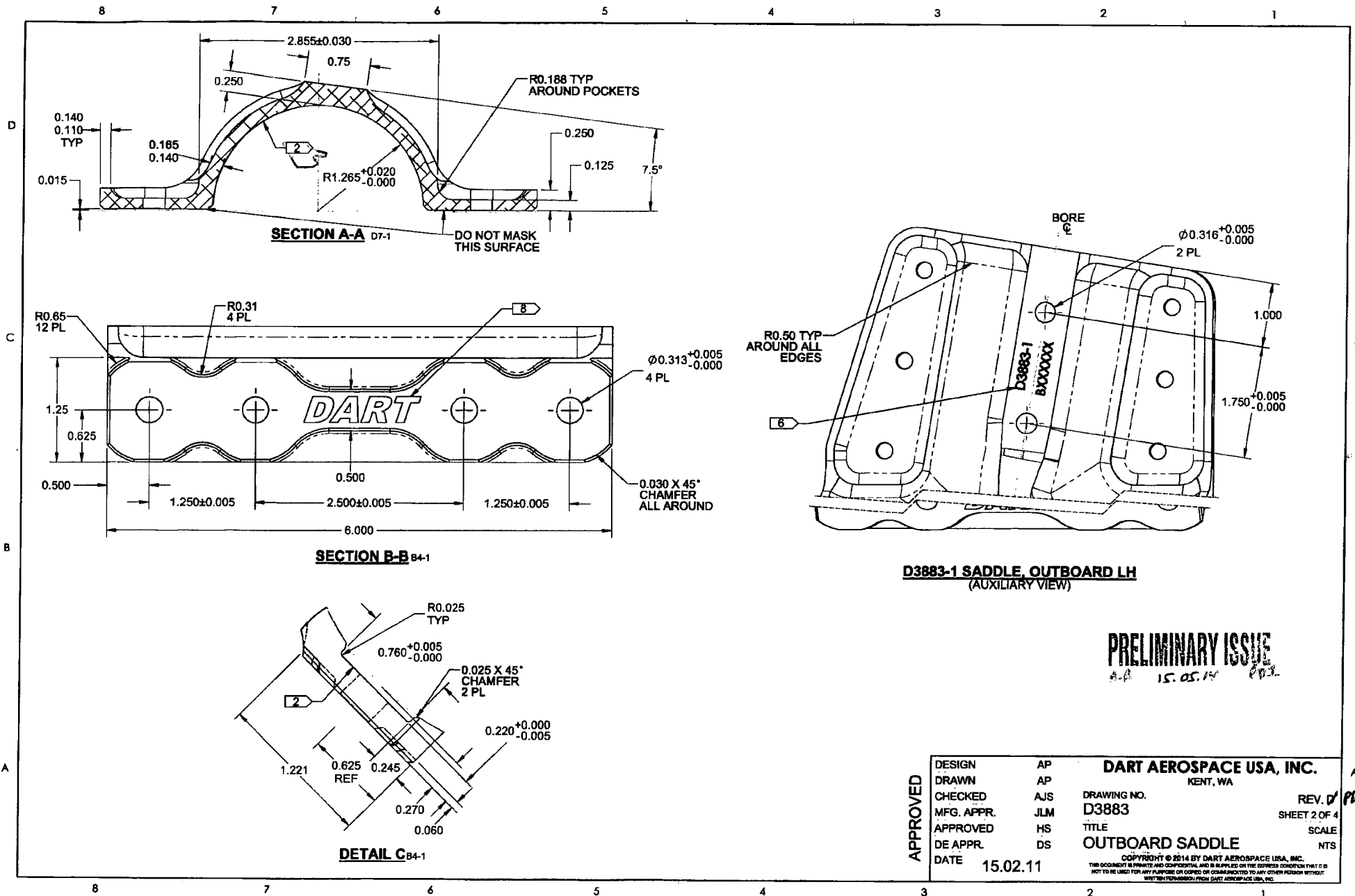
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☒</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

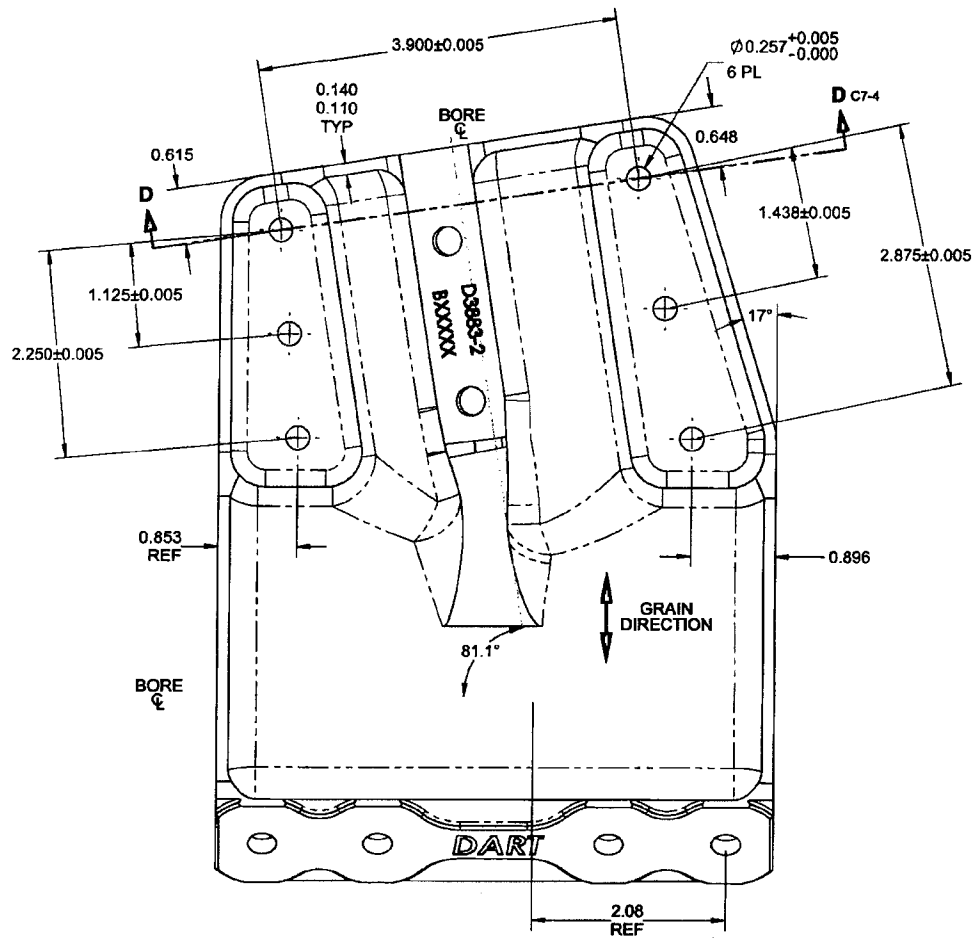
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	15.05.14	140	6	NO POWDER COAT ON CONCAVE SURFACES MATERIAL WITH X-TUBE & SKIDS	A.P.	ACCEPTABLE PER ATTACHED PRELIM DWG	23 23 23	DAS 9 9-89	DAS 9 9-89
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☒ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☒ Other
		<u>customer request</u>



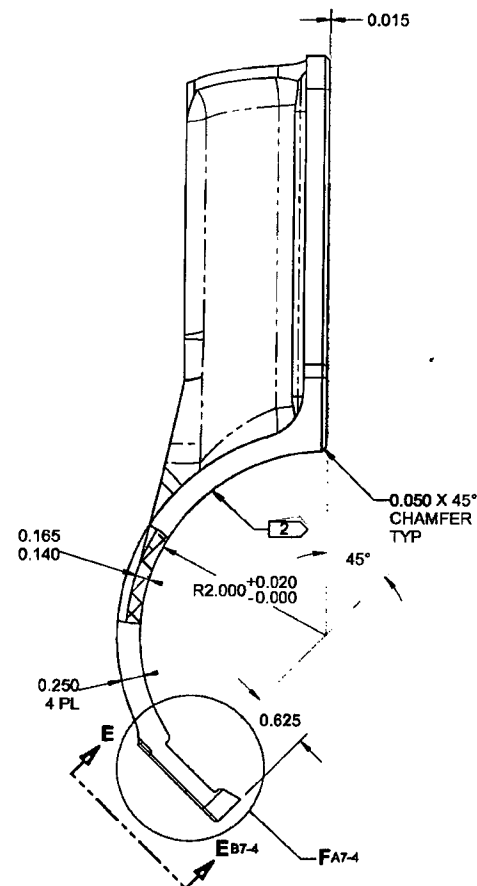




D3883-2 SADDLE, OUTBOARD RH

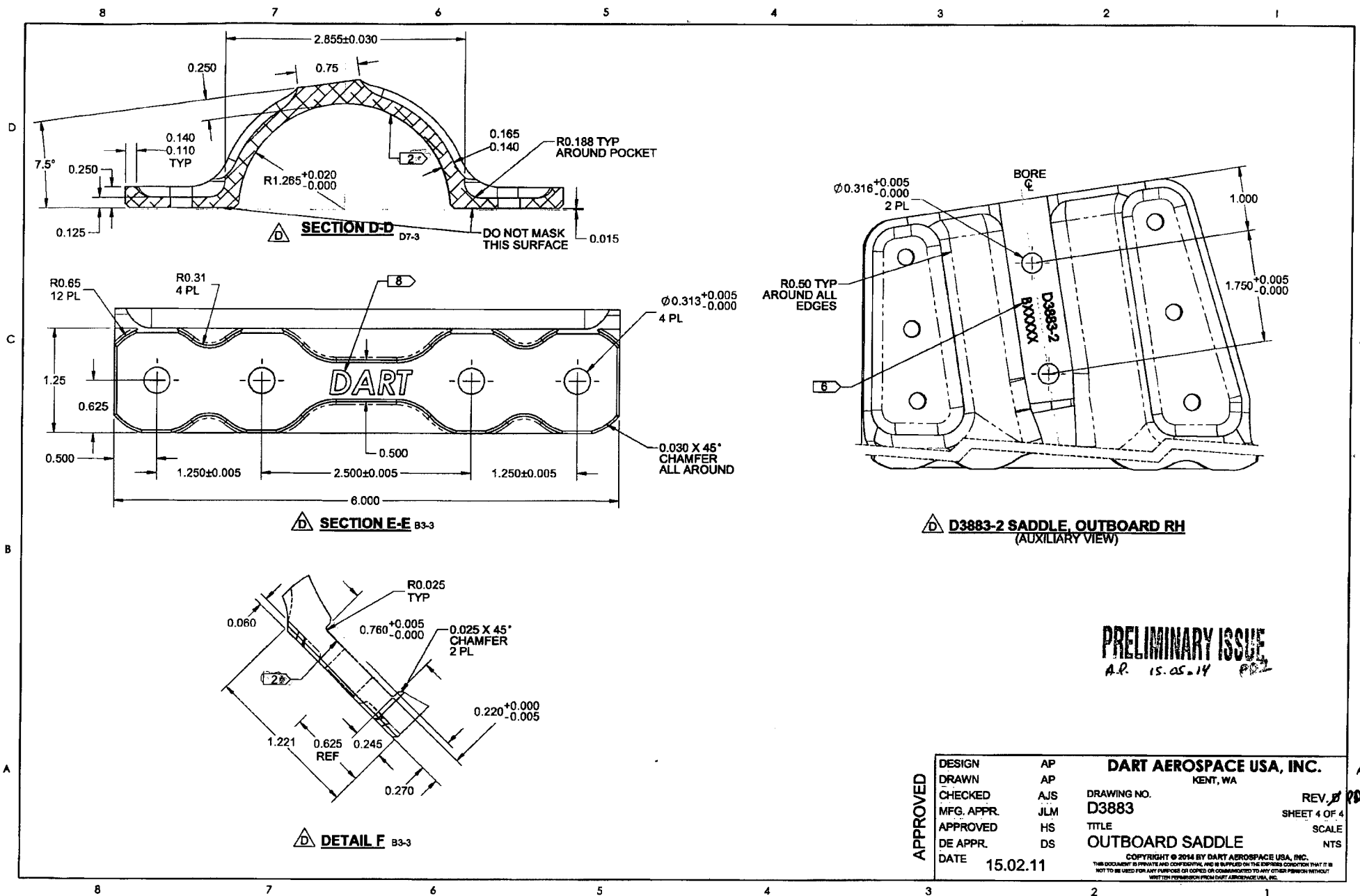
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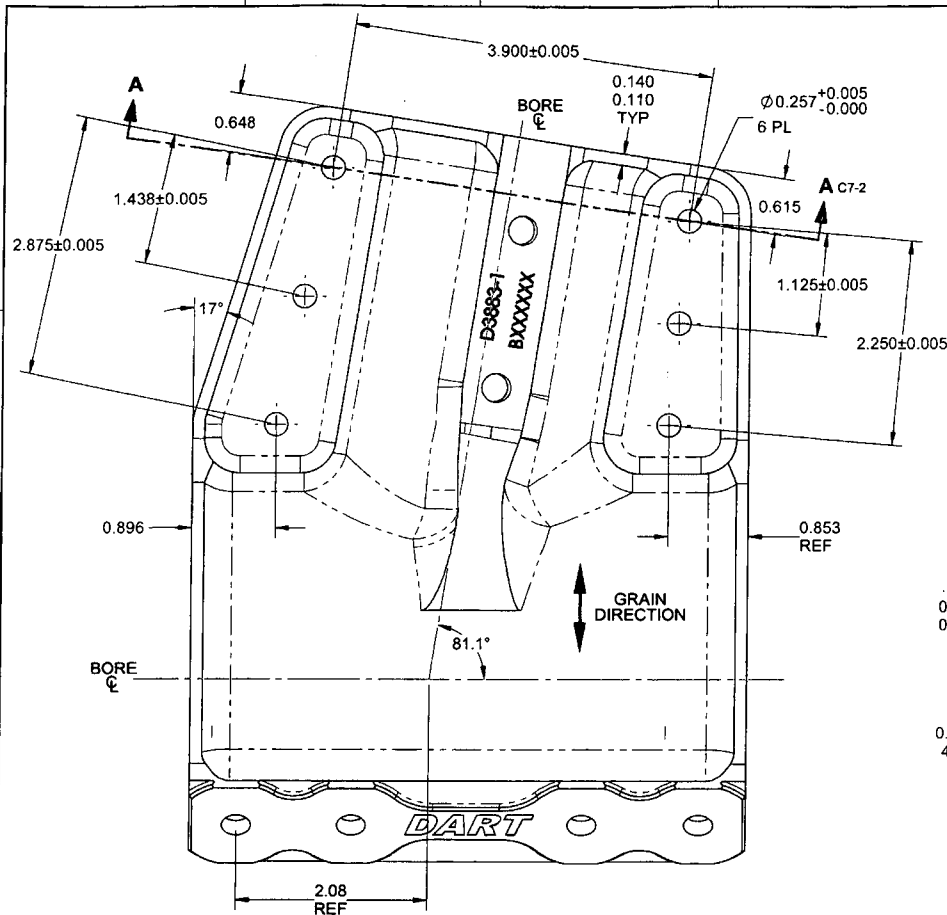
- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D8101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REV.D.SLDPRT"



PRELIMINARY ISSUE
A.P. 15.05.14 001

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA		REV. D 002
	DRAWN	AP			
	CHECKED	AJS	DRAWING NO. D3883		SHEET 3 OF 4
	MFG. APPR.	JLM	TITLE OUTBOARD SADDLE		SCALE
	APPROVED	HS	DATE 15.02.11		NTS
	DE APPR.	DS	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

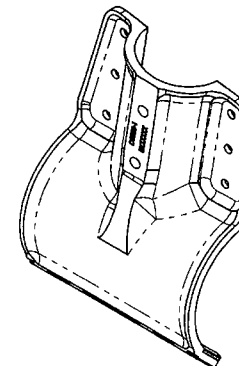
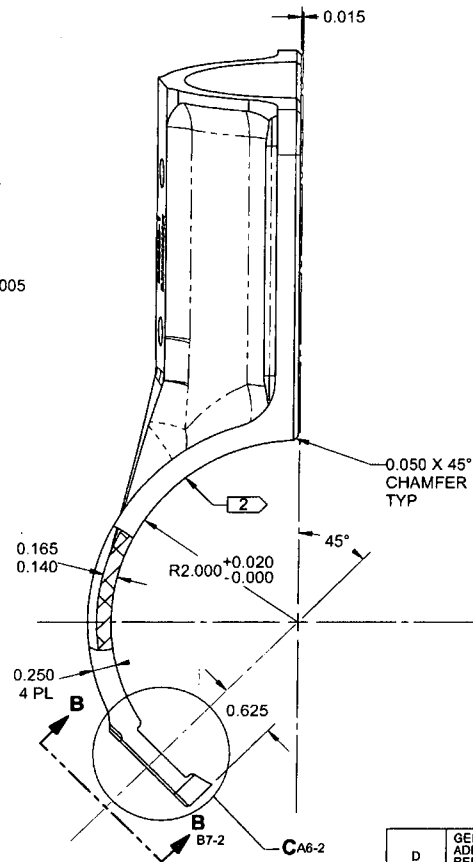




D3883-1 SADDLE, OUTBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-1-REV.D.SLDPRT"



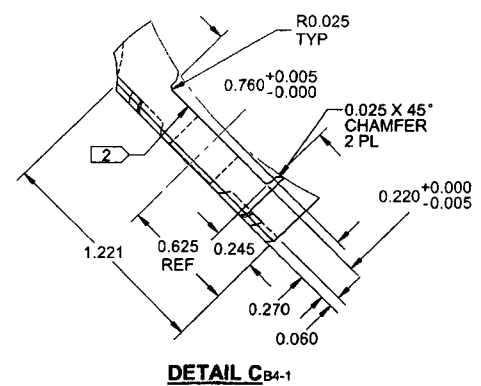
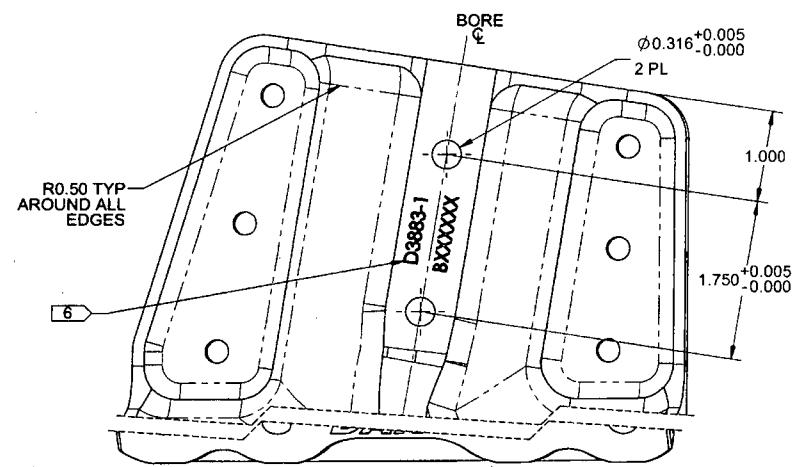
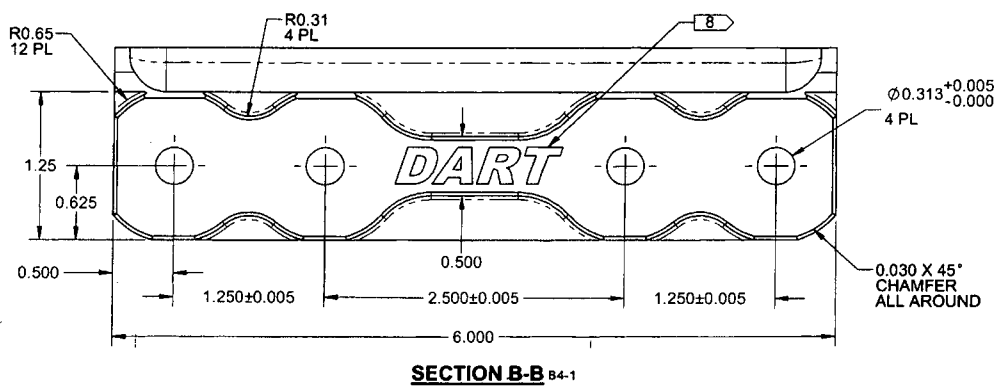
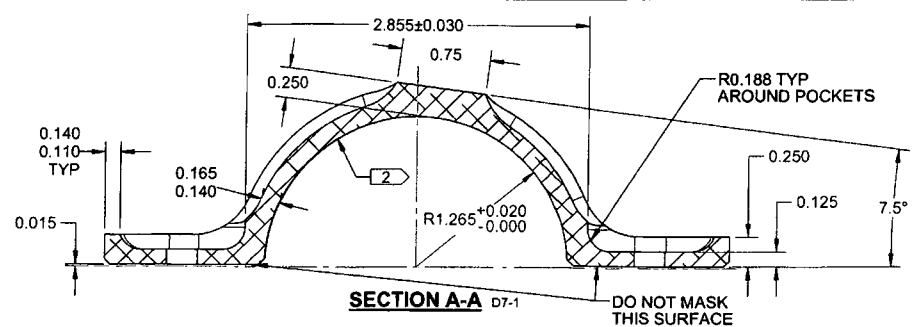
RELEASED

2015 MAY 19

A.P. ECWIS-575

REV.	DESCRIPTION	BY	DATE
D	GENERAL REDRAW, ADDED D3883-2 ON SHEETS 3 & 4, ADDED NOTE 9 & REMOVED UNNECESSARY DIMS. REMOVED POWDER COAT ON INSIDE SURFACE OF D3883-1/2	AP	15.02.11
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D8101-015, ZN A7-1; ADD 0.648, ZN D7-1; ADD 0.615, ZN D6-1; ADD 0.125, ZN D7-2; ADD 0.060 & R0.031, ZN B5-2; 0.75 WAS 0.728, ZN C7-2	RF	09.08.30
A	NEW ISSUE	RF	09.03.30
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D3883 TITLE OUTBOARD SADDLE SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	AP		
CHECKED	AJS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	REV. D SHEET 1 OF 4 DATE 15.02.11	

APPROVED



D3883-1 SADDLE, OUTBOARD LH
(AUXILIARY VIEW)

RELEASED
P.R. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
DATE		15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	